

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010471**Date Inspected:** 30-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Liang Zhu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD****ULTRASONIC INSPECTION****OBG SEGMENT 1AW -1BW**

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the bottom panel splice weld between OBG segment 1AW and 1BW (OBW1A-008) utilizing scanning pattern A, B, C and D (Fig 6.7).

**BLASTING SHOP****VISUAL INSPECTION****OBG SEGMENT 7EE**

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This Quality Assurance (QA) Inspector performed random visual inspection after blasting along with Caltrans Quality Assurance (QA) Inspector Mr. Daniel on inside bottom panel and side panel OBG segment 7DE. During the inspection we found normal minor gouges, arc strikes, spatter, undercut like discontinuities. For additional information see attached photo.

BAY #10

This QA Inspector randomly observed the following work in progress.

### NORTH TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Cored Arc Welding process for the weld NSTL4-3J/L-114 located on PCMK North tower lift 4. ZPMC QC Mr. Gong Liang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201825 performing Flux Cored Arc Welding process for the weld NSTL4-3J/L-42 located on PCMK North tower lift 4. ZPMC QC Mr. Gong Liang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for the weld NSTL4-3I/L-114 located on PCMK North tower lift 4. ZPMC QC Mr. Gong Liang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



### Summary of Conversations:

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer